

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017499**Date Inspected:** 28-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Yu Dong Ping/ Mr. Zhao Chen			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Heavy Dock –Tower Trial assembly

1. This QA inspector, Baskar Govindarajan, performed, misalignment, Gap measurements of Interior splice plates of Skin A, B, C, D and E between East shaft Lift 3 & 4. This measurement of gap and misalignment was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227. All the reading taken has handed over to Task Leader. (Photo attached)
2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052930 / 050038 perform SMAW welding on; Tower Façade plate with Skin E in North shaft, Lift 3 of 109 mtr. elevation and the weld joint is identified as NSD1-FESA3-1 D/D- 12, 13. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113. (Photo attached)
3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040365 / 057220 perform SMAW welding on; Tower Façade plate with Skin E in South shaft, Lift 3 of 109 mtr. elevation and the weld joint is identified as SSD1-FESA3-1 D/D- 12, 13. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay no. 12

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 062259 perform FCAW welding on; OBG Splice plate sub assembly and the weld joint is identified as SA 3051B-034-004, 003. ZPMC CWI Identified as Mr. Yang Bai Qiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-TC-U4B-F.

Bay no. 11

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044541/ 054460 perform SMAW welding on; Tower Lift 5 Bracket components and the weld joint is identified as ND1-BRSA5-2- 11A, 7A. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4B.

Bay no. 10

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 056200 / 056364 perform SMAW welding on; Tower Façade plate assembly and the weld joint is identified as ND1-SFSA4-328 A/B-5, 6. ZPMC CWI Identified as Mr. Zhang Huang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114.

7. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053116 / 054069 perform FCAW welding on; Tower Façade plate assembly and the weld joint is identified as SD1-SFSA4-328 A/B-18, 19. ZPMC CWI Identified as Mr. Zhang Huang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2133.

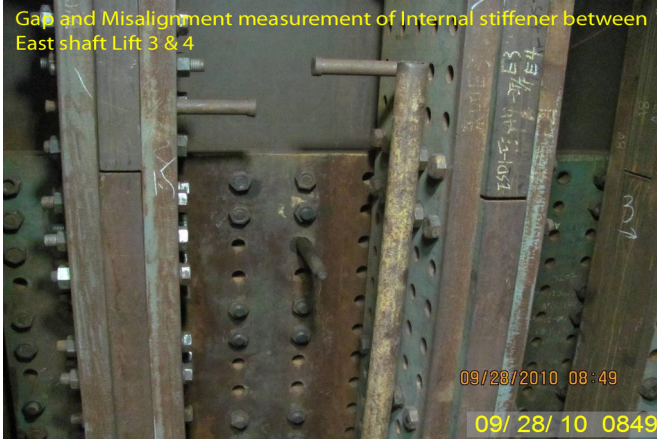
8. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769 perform SMAW Repair welding on; East Tower, Lift 5, Grillage plate and the weld joint is identified as ESD1-TL5-2 E/F- 20A/B . ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-3G (3F)- Repair.

9. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066326 perform SMAW Repair welding on; West Tower, Lift 5, Grillage plate and the weld joint is identified as WSD1-TL5-4 E/F- 5A/B . ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-3G (3F)- Repair.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer